

Work Order ID 84154

Friday, May 04, 2012 1:07:03 PM

ASAP
84154

Ship May 15th Page 1

Item ID: D4082-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mounting Bracket

Start Date: 5/4/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/11/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: P

Date: 12-05-4

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4082	A								

100

0.00

100

BAND SAW

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut blankAS per file D4082-1_BLANK

6061 1" x 12

RD-5-7

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA919

FOLIO REV: A

DWG REV: 12

SL 12-05-08

RD-5-7

DEBURR

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	<i>SL</i>	<i>12-05-08</i>		<u>4</u>	<u>0</u>		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>SL</i>	<i>12/05/08</i>		<u>4</u>	<u>0</u>		
140 *140* Small Fab Small Fab	Small Fab Memo Drill holes as per dwg D4082 using DT8560	0.00 0.00	<i>AO</i>	<i>12-05-09</i>		<u>4</u>			

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

170

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3200 F

9-10

M121134

H φ BL 1259.

4X φ M/A 12/05/10

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

4 0 12-5-10

190

Identify as per dwg & Stock Location 166

0.00

190

Packaging

Memo

0.00

Packaging

(4) 12-5-10

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/5/10

MCS 12/05/10

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 84154

84154

Parent Item: D4082-1

D4082-1

Parent Item Name: Mounting Bracket

Start Date: 5/4/2012

Required Date: 5/11/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-03-30 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B1.000X12.00
0

Purchased

No

f

18.5000

9.122526

M6061T6B1 000X12 000

**

6061-T6 Bar 1.00 x 12.00

Location

Loc Qty

Loc Code

MAT005

18.5

115844

12

116406

6.5

115844

8425-7

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	84154
Description: Mounting Bracket		Part Number:	D4082-1
Inspection Dwg: D4082 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.13	+/-0.030	26.13	/		m-tape	
Ø0.257	+0.006/-0.001	0.257	/		vern	SL-10
R0.38	+/-0.030	0.38	/		R-G	
1.076	+/-0.010	1.076	/		vern	SL-10
6.72	+/-0.030	6.719	/		vern	CNC-02
1.985	+/-0.010	1.985	/		"	SL-10
0.440	+/-0.010	0.440	/		-	"
R0.25	+/-0.030	0.250	/			
4.00	+/-0.030	4.00	/		H-G	
9.372	+/-0.010	9.372	/		"	
13.848	+/-0.010	13.849	/		H-G	
Ø0.191	+0.005/-0.001	0.193	/		vern	SL-10
1.035	+/-0.010	1.035	/		vern	SL-10
0.500	+/-0.010	0.501	/		"	"
2.776	+/-0.010	2.776	/		"	"
8.00	+/-0.030	8.001	/		"	CNC-02
7.546	+/-0.010	7.546	/		"	"
1.000	+/-0.010	1.001	/		"	SL-10
3.290	+/-0.010	3.286	/		"	"
3.11	+/-0.030	3.106	/		"	"
0.250	+/-0.010	0.249	/		"	"
4.720	+/-0.010	4.718	/		"	"
6.37	+/-0.030	6.368	/		"	CNC-02
2.35	+/-0.030	2.351	/		"	SL-10
2.76	+/-0.030	2.758	/		"	/
3.13	+/-0.030	3.128	/		"	/
0.13 x 45°	+/-0.030 x +/-0.5°	0.110 x 45°	/		"	"
0.06 x 45°	+/-0.030 x +/-0.5°	0.045 x 45°	/		"	"
0.125	+/-0.010	0.126	/		mic	118-120
R0.250	+/-0.010	0.250	/			
R0.125	+/-0.010	0.125	/			
0.875	+/-0.010	0.875	/		vern	SL-10
0.750	+/-0.010	0.744	/		"	"

Measured by:	SL	Audited by:	AM	Preliminary Approval:	
Date:	12/05/08	Date:	12/05/08	Date:	

Rev	Date	Change	Revised by	Approved
A	10.04.20	New Issue	KJ	

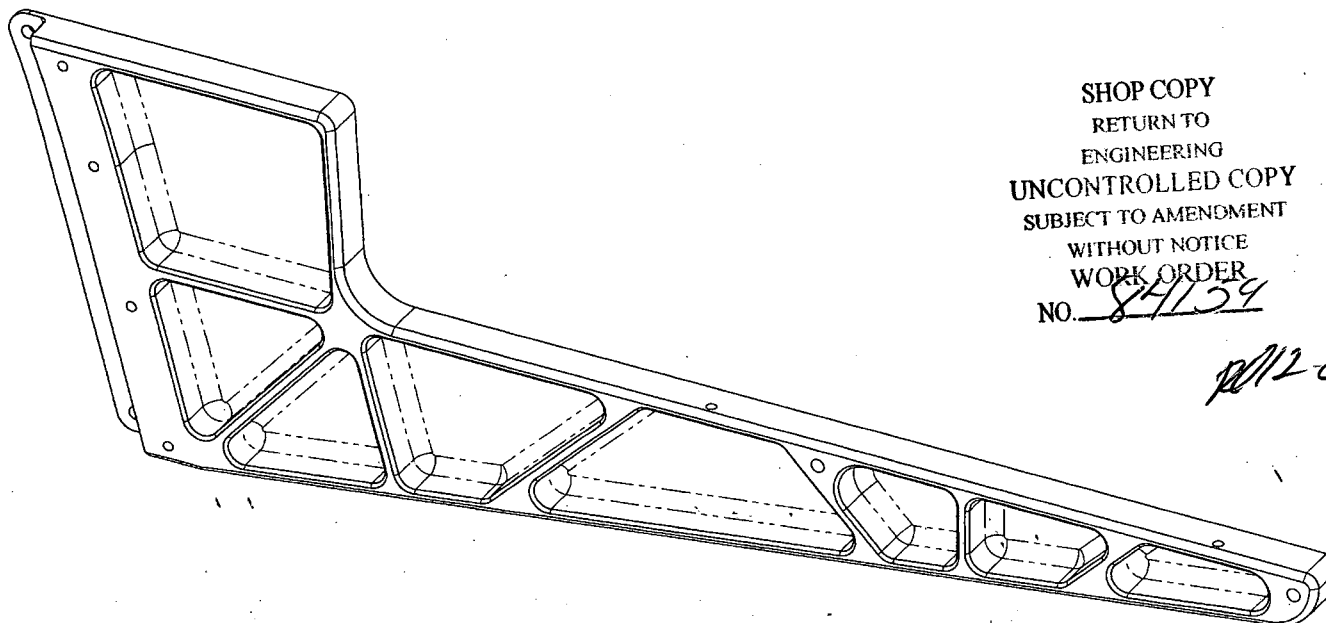
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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 84134

11205-4

D4082-1 MOUNTING BRACKET

RELEASED
 2010-03-30
not

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET (OR PLATE)
 PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR
 AMS 4025 OR AMS 4027
 OR ASTM B209
 REF. DART SPEC. M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4082-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.61 lbs

A	NEW ISSUE	MB	10.03.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.22		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4062	REV. A
TITLE MOUNTING BRACKET	SCALE NTS
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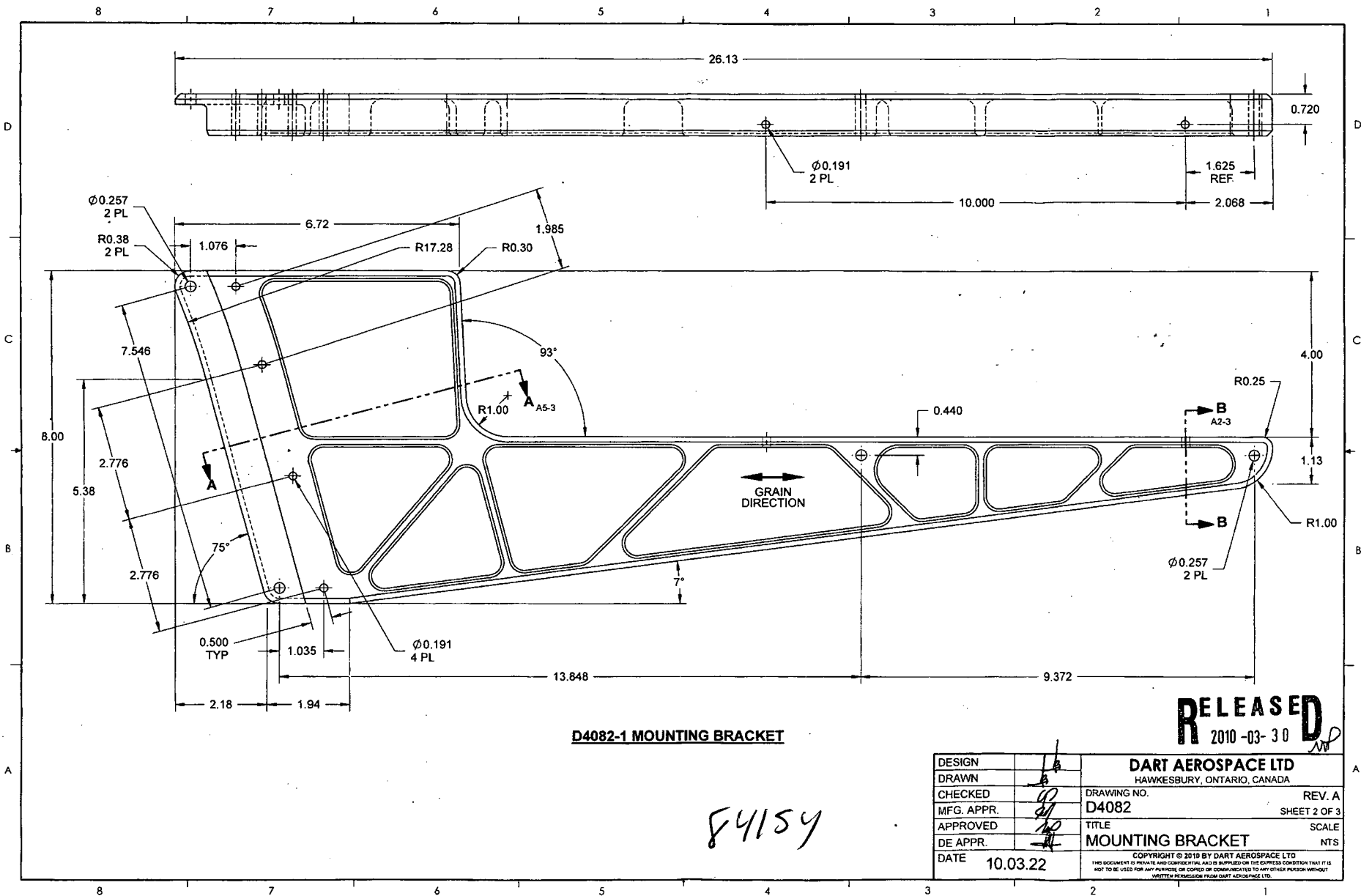
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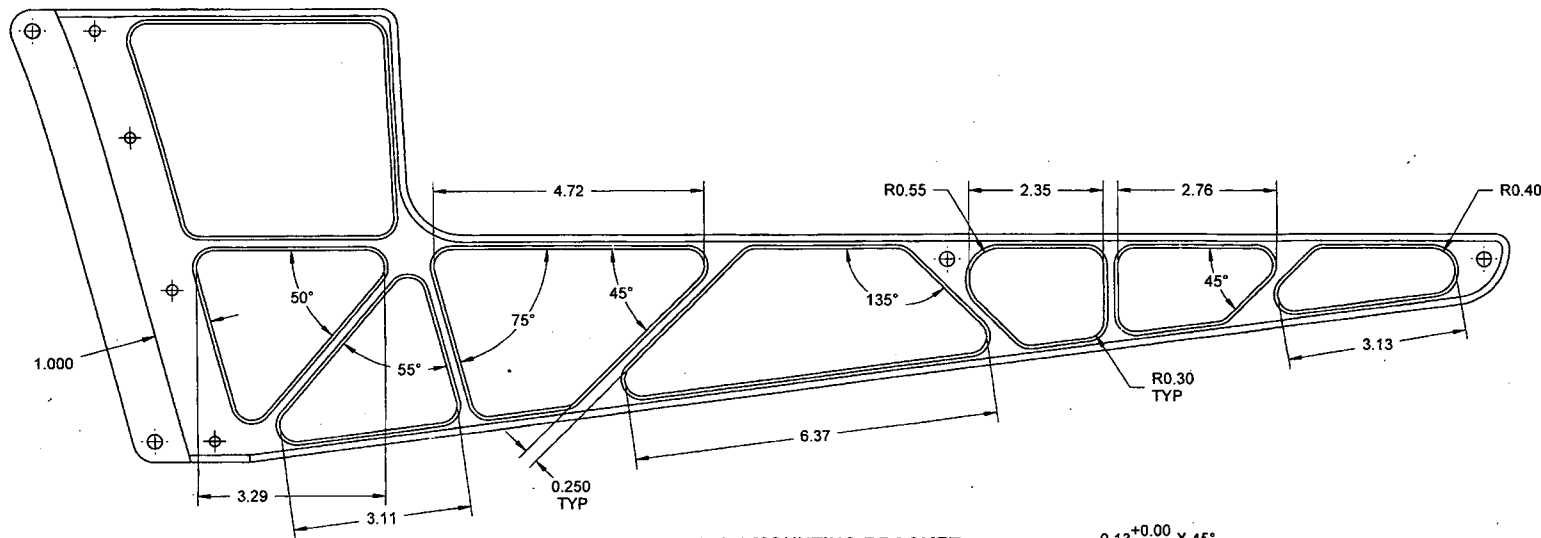
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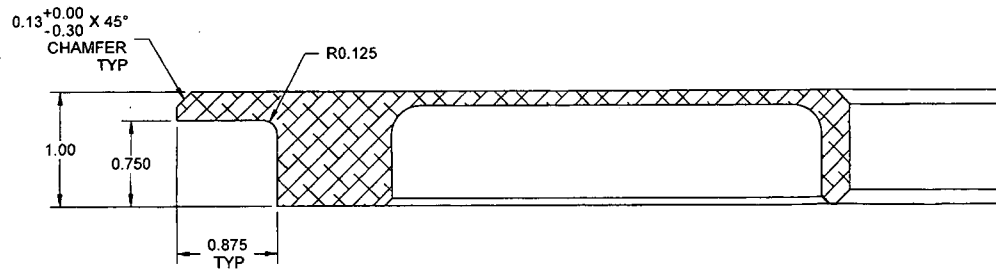
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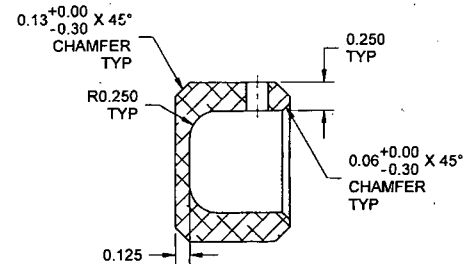
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D4082-1 MOUNTING BRACKET
SUPPLEMENTAL VIEW



SECTION A-A C5-2
SCALE 2X



SECTION B-B C1-2
SCALE 2X

RELEASED
2010-03-30

DESIGN	LA	DART AEROSPACE LTD	
DRAWN	LA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	92	D4082	SHEET 3 OF 3
APPROVED	92	TITLE	SCALE
DE APPR.	LA	MOUNTING BRACKET	NTS
DATE	10.03.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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